

Work Order ID 85899

85899

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June-18-12 1:00:14 PM

Item ID: D2596

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web, 205 Skidtube

Start Date: 18/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 12/06/18 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2596	Rev D								
100		0.00							
100	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr								
110	Chemical Conversion Coat per QSI005 4.1	0.00							
110									
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

4 Ø CF 12-7-124 Ø 12-7-124 Ø 12-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

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Revision ID:

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Stop ***NS2***

Start Date: 18/06/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: **LG**

0.00

130

Packaging

Memo

0.00

Packaging

4 **0** **CF 12-7-12**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MCS 12/07/12

MCS 12/07/12

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 18/06/2012

Required Date: 02/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	4.0000	1	4			
D2500-3-100									**	(4)		CF 12-7-11	
Ext'n - I' Beam Web 4"													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				4					
					51957			2					
					79041			2					

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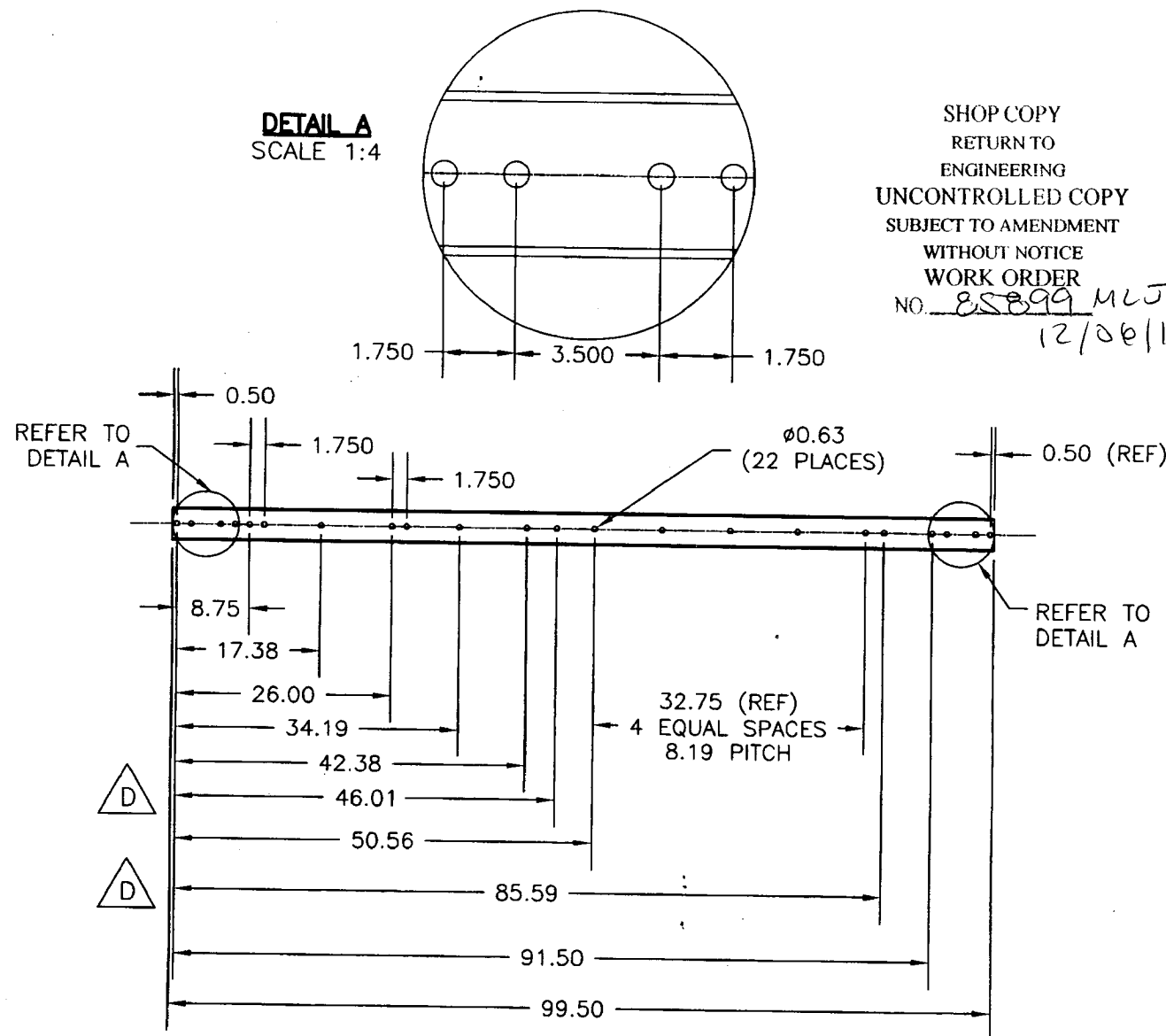
DART

RELEASED
07 DEC 28 1971

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 85899 MLJ
12/26/18

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
84	84	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
84	84	D2596	
DATE	TITLE	SCALE	
07.04.17	205 WEB	1:20	
A	96.09.16	NEW ISSUE	
B	97.07.23	0.63 HOLE WAS 0.56	
C	98.09.14	INCORPORATED DEO 9097	
D	07.04.17	INCORPORATED DEO 9183	

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